

Date: Thursday, 01/05/2008 12:48:24 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 38950		
Estimate Number	: 10178		
P.O. Number	:	Part Number	: D25941
This Issue	: 01/05/2008	Drawing Number	: D2594 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: C
Previous Run	: 37926	Material	:
Written By	:	Due Date	: 20/05/2008
Checked & Approved By	: <u>JLD 08.5.0</u>	Qty:	500 Um: Each
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)
 Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)
 1100-0 (QQ-A-225/1) Ø0.625" Rod
 (M5052H32R0.625) or (M6061T6R0.625) Batch M106634 mmf 08/05/02

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-Make as per Dwg D2594-1 and Folio FA262.
 2-Break all sharp edges 0.010 max. mmf 08/05/02 20 08/05/03

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE mmf 08/05/02 20 08/05/03 (502)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK 20 08/05/03 (502)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and alodine as per QSI 005 4.1 FL 08/05/06 (502)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M107550



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

START TIME: 3:00pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:30pm

JJ S

08-05-08 (502)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(502X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

08/05/08

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(502X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-P 1

M-L

08/05/08

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-L 08-05-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

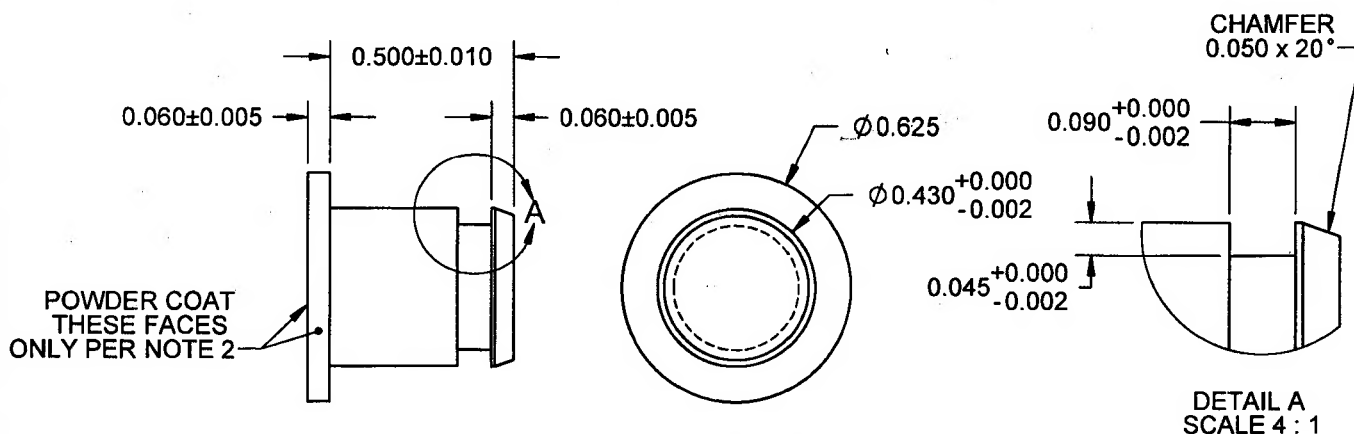
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG SCALE 2:1	
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
06.11.28 [Signature]



D2594-1 PLUG

D2594-1 PLUG NOTES:

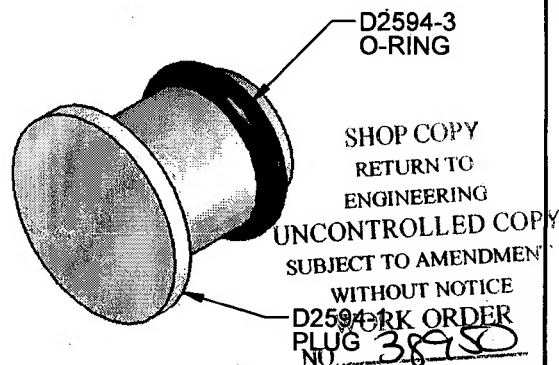
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 $\triangle C$

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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